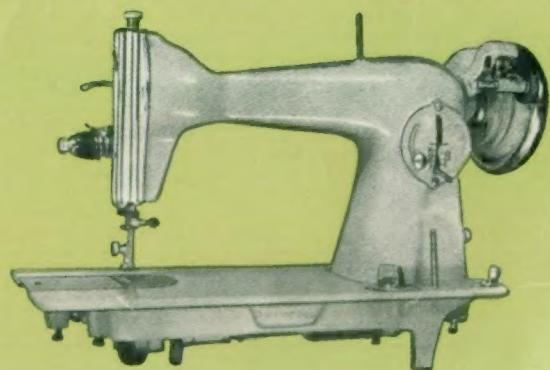
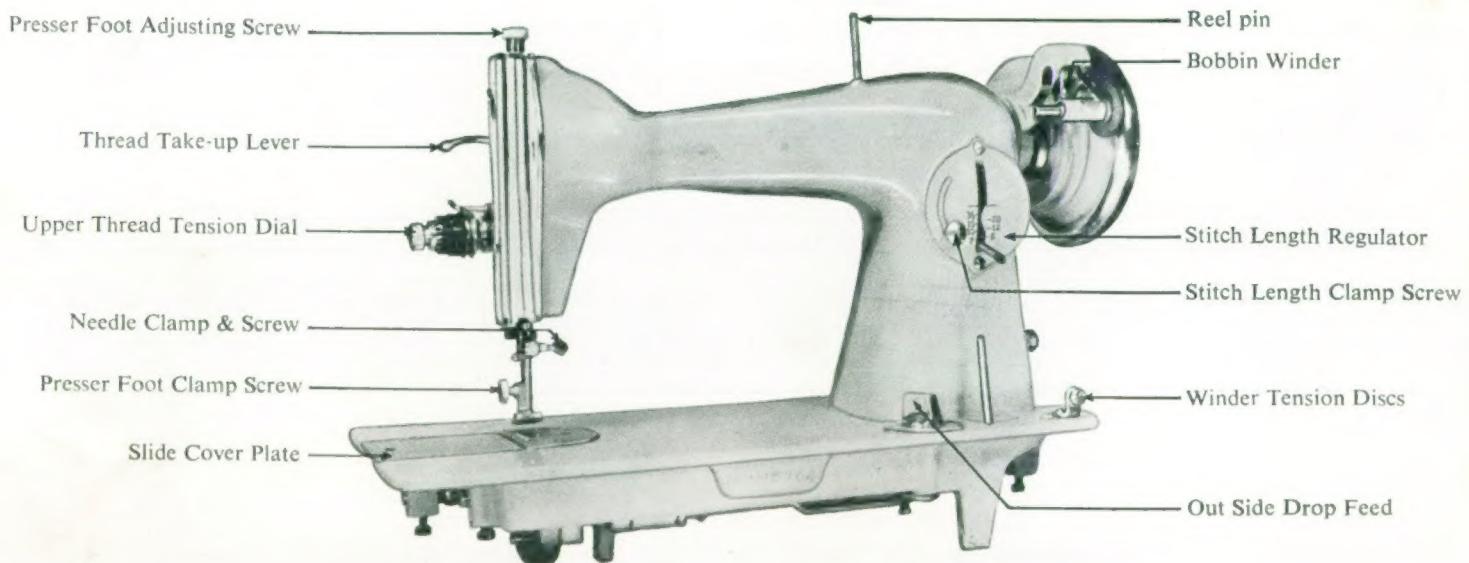


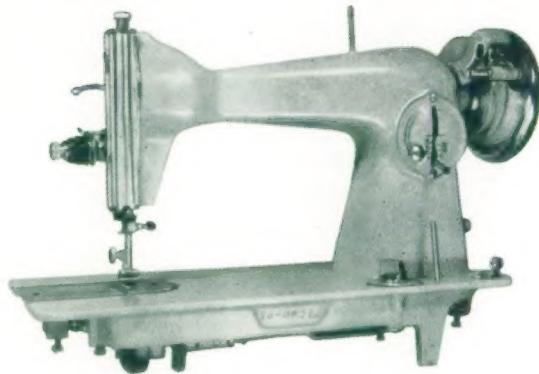
# YOUR JONES C. B. MODEL D-68 MACHINE

*Manual  
of Instruction*



JONES C. B.  
MODEL D-68





## Your Precision Sewing Machine

- ★ Synchromatic stitch regulator.
- ★ Instant reverse sewing.
- ★ Numbered thread tension regulator.
- ★ Automatic self-adjusting bobbin winder.
- ★ Snap out race.
- ★ Automatic tension release.

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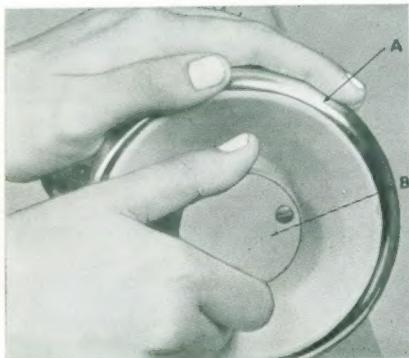
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## Congratulations !

You are now the owner of a precision-engineered Domestic Sewing Machine. Give your machine proper care and it will provide many years of trouble-free service.

### Important

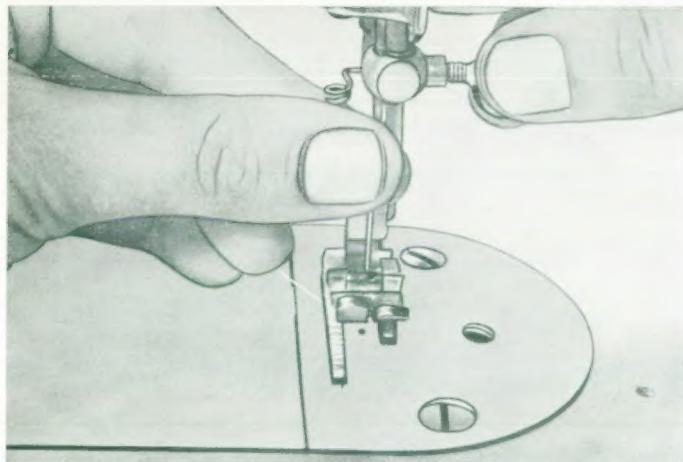
Please read this Instruction Book carefully. Your machine was thoroughly tested before despatch to make sure it sewed perfectly. If you follow these instructions your machine will operate perfectly.



### 1. TO OPERATE BALANCE WHEEL AND STOP MOTION

The center of the balance wheel (A) is equipped with a stop motion knob (B). Hold the balance wheel firmly with your left hand and turn the stop motion knob towards you, thus permitting the balance wheel to run freely, so that the bobbin can be wound without operating the stitching mechanism.

To lock balance wheel, turn the stop motion knob away from you.



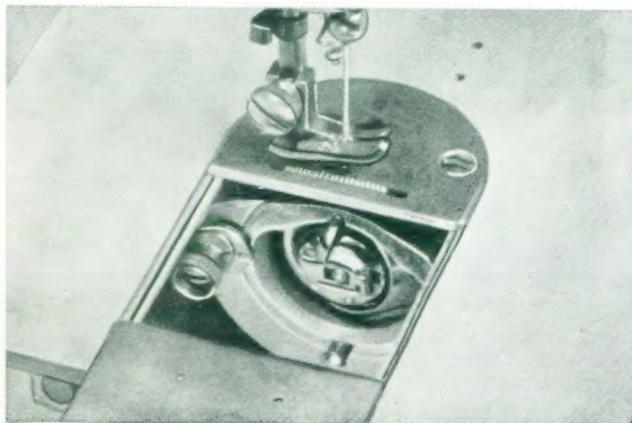
## 2. TO SET THE NEEDLE

Turn the balance wheel towards you until the needle bar reaches its highest position.

Loosen the needle clamp screw.

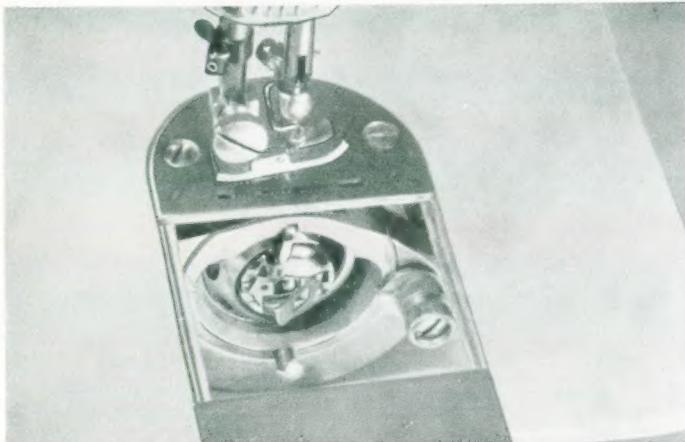
Insert the needle with the flat side towards the balance wheel and push the needle up into the needle clamp until it hits the stop.

Tighten the needle clamp securely.



## 3. THE SLIDE COVER PLATE

Access to the bobbin case is obtained by sliding the cover plate to the left as shown.



Correct winding



Incorrect winding



#### 4. TO REMOVE THE BOBBIN CASE

Turn the balance wheel towards you until the needle bar is at its highest position.

Slide open the cover plate and insert thumb and forefinger of left hand.

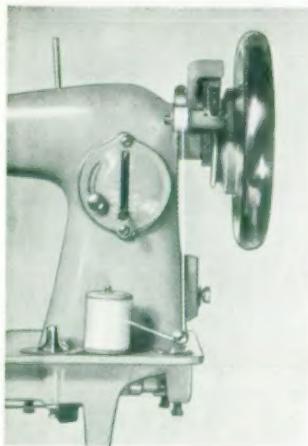
Open the latch of the bobbin case as shown and take out the bobbin case by holding the latch.

Shut the latch and face the mouth of the bobbin case downwards, and the bobbin will fall out.

**Important**—The shuttle hook and bobbin case can be knocked out of position if you use a bent needle, or try to take out the bobbin case when the needle bar is lowered.

#### 5. TO ADJUST WINDING ON THE BOBBIN

In order to ensure smooth rotation of the bobbin within its case, make sure that the thread is wound evenly on the bobbin, otherwise it will cause the thread to break, irregular tension, or fail to produce neat stitches.



## 6. TO WIND THE BOBBIN

Loosen the balance wheel as shown on Page 3.

Place the spool of thread on the bobbin winder spindle and draw out about 12" of thread through tension bracket. Wind thread on to the bobbin seven or eight times towards you. Then set the bobbin on the spindle (A) of the bobbin winder. Should the bobbin wind unevenly, slide tension bracket to left or right as required.



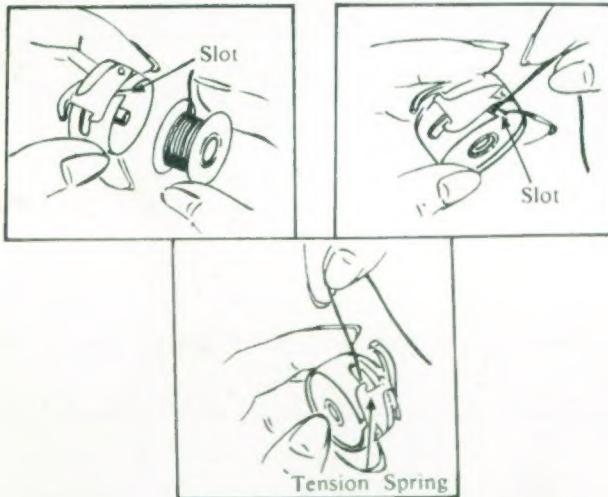
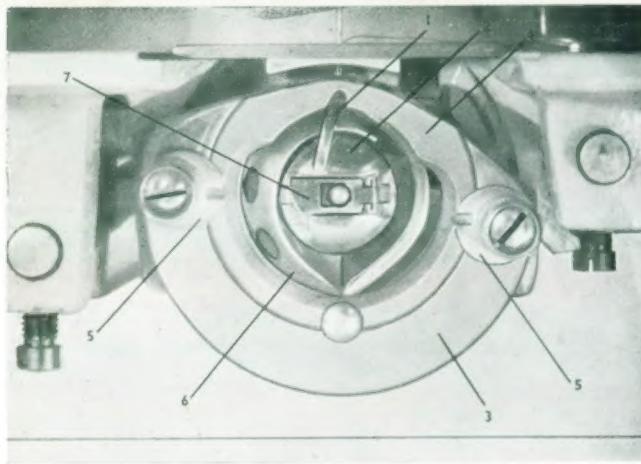
To set the bobbin, put the bobbin on the spindle (A) as shown, pushing up the stop latch (B).

After setting the bobbin, push the lever (C) down and the rubber ring (D) will touch the balance wheel. Then turn the balance wheel towards you and run the machine slowly to wind the bobbin evenly.

When the bobbin is full, it will automatically come to a stop.

Cut the thread and remove the bobbin and retighten balance wheel for sewing.

In order to sew and wind your bobbin simultaneously, do not loosen the balance wheel.



## 7. TO SET THE BOBBIN CASE

Turn the balance wheel towards you until the needle bar is at its highest position.

Hold the latch of the threaded bobbin case between the thumb and forefinger of the left hand, replace the bobbin case as shown (See Page 13).

At the time, make sure that the bobbin case position finger is fixed in the notch of shuttle race.

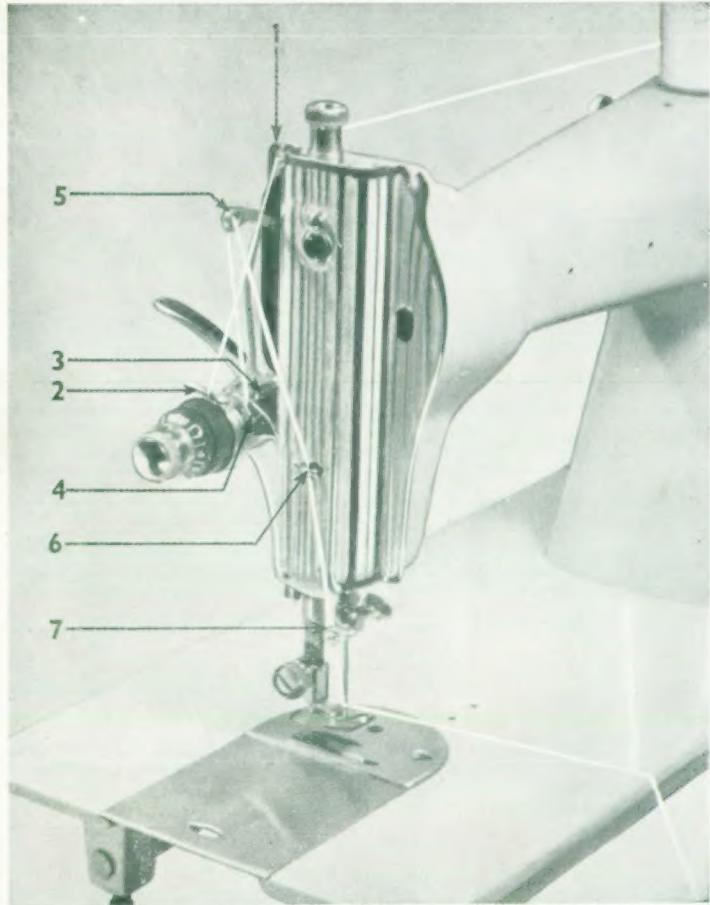
(1) Position Finger. (2) Bobbin Case. (3) Shuttle Race. (4) Race Ring. (5) Clips. (6) Shuttle Hook. (7) Latch.

## 8. TO THREAD THE BOBBIN CASE

Hold the bobbin case between the thumb and forefinger of your left hand with the slot in the edge facing up.

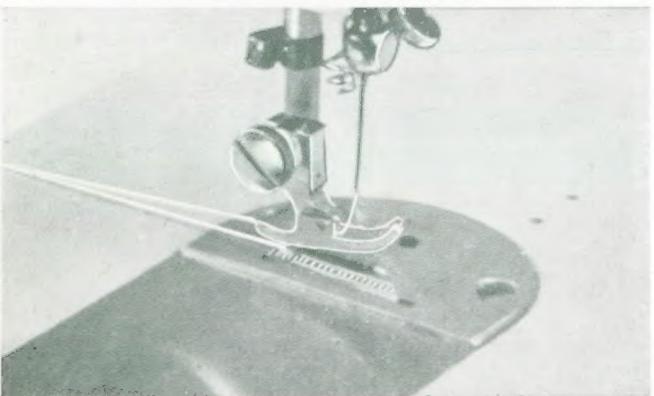
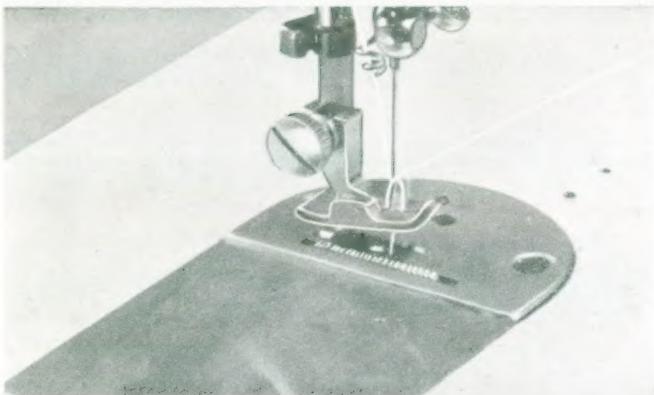
Hold the wound bobbin between the thumb and two fingers of your right hand with the thread on top leading away from you (See pictures).

Insert the bobbin into the case, pull the thread into the slot, then down under the spring until it enters the delivery eye.



#### 9. TO THREAD THE NEEDLE (Upper Thread)

- (a) Turn the balance wheel towards you until the thread take-up lever (5) is RAISED TO ITS HIGHEST POINT. Place a reel of thread on the reel pin; draw the thread towards the left through the notch (1) down under and around from back to front between the tension discs (2), up over the thread guard (3) from the back down into the loop of the take-up spring (4), up and from the back through the eyelet in the end of the take-up lever (5), down through the eyelet (6) into the guide (7) and from left to right through the eye of the needle.
- (b) Draw about three inches of thread through the eye of the needle with which to commence sewing.



## 10. TO PREPARE FOR SEWING

- (a) Pull sufficient thread through the needle and with the left hand hold the end, leaving it slack from the hand to the needle.
- (b) Turn the balance wheel towards you until the needle moves down and up again, thus catching the under thread.
- (c) When the take-up lever is at its highest point, pull the end of the needle thread you are holding and the under thread will be brought up with it through the needle hole in the throat plate, as shown.
- (d) Lay both ends of thread under and to the back of the presser foot, and having inserted the material to be stitched, lower the presser bar lifter and commence to sew by turning the balance wheel towards you.
- (e) It is advisable to test the tension and the stitch length on two places of scrap material before starting to sew the actual garment.

**Note**—Do not try to help the feeding of the work by pulling the material, as this may deflect the needle and cause it to break. The machine feeds without any assistance.

**Important Note**—Never operate the machine without material under the presser foot. If this is not strictly adhered to, your machine will lock, and cannot be operated until the thread is cleaned out of the race.



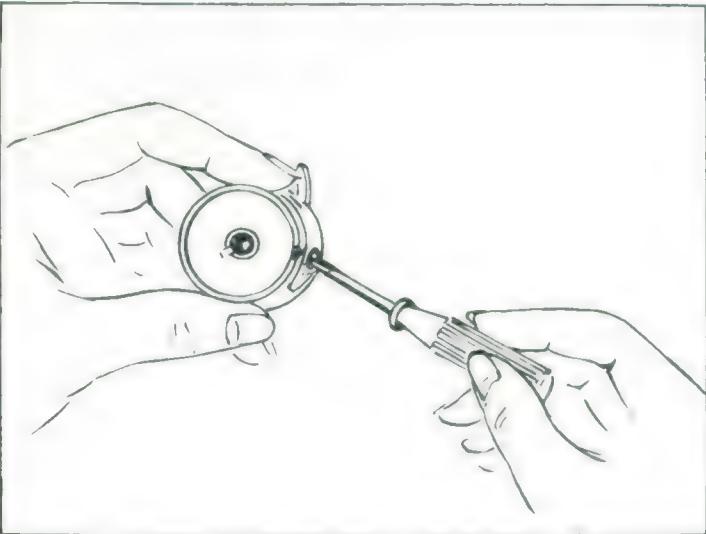
#### **11. TO REMOVE THE MATERIAL**

- (a) Stop the machine when the needle is at its highest point.
- (b) Lift the presser bar lifter and draw the material to the left hand side.
- (c) Passing the threads over the threads cutter as shown, pull down lightly and cut the threads.
- (d) Always leave three to four inches of thread for the next sewing.



#### **12. TO ADJUST THE UPPER THREAD TENSION**

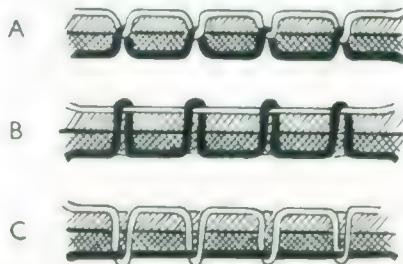
- (a) In most cases the perfect stitch can be obtained by regulating the upper thread tension. To increase the upper thread tension, turn the tension regulating dial clockwise, and to decrease, turn it anti-clockwise.
- (b) The tension regulator should not be turned abruptly but little by little until the desired tension is obtained, and always make sure that the presser foot is down.



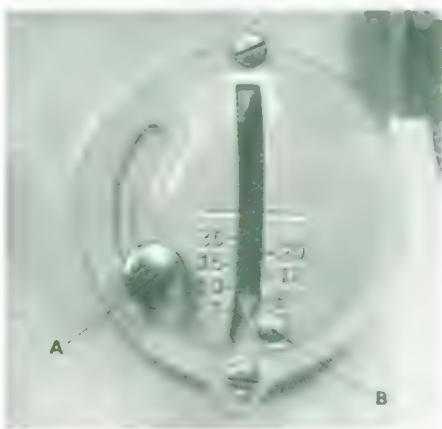
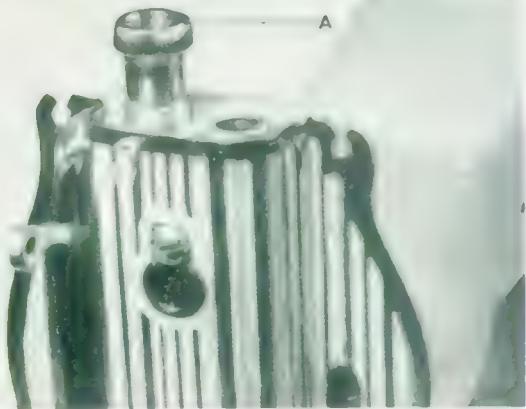
### 13. TO ADJUST LOWER THREAD TENSION

All machines are correctly adjusted before leaving the factory, therefore it is seldom necessary to alter the LOWER tension. Should it become necessary, however, to do so, tighten the tension spring screw to increase the tension and loosen the screw slightly to lessen the tension, using the small screw driver provided for the purpose (See picture).

### 14. THREAD TENSION



- (a) For ordinary stitching, the needle and the bobbin threads should be locked in the center of the thickness of the material, as illustrated (A).
- (b) If the tension on the needle thread is too tight, or if that on the bobbin is too loose, the needle thread will lie straight along the upper surface of the material, as shown in illustration (B).
- (c) If the tension on the bobbin thread is too tight, or if that on the needle is too loose, the bobbin thread will lie straight along under side of the material, as shown in illustration (C).



## 15. TO REGULATE PRESSURE ON MATERIAL

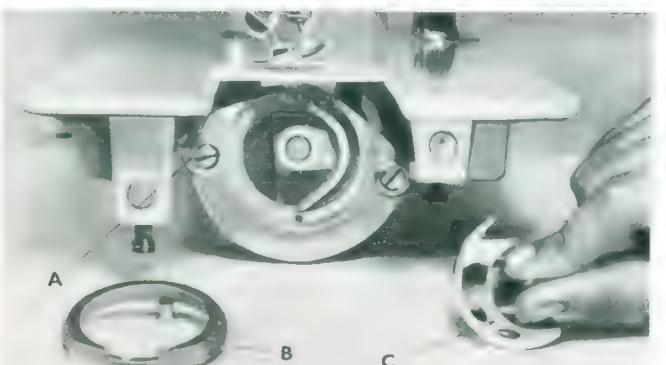
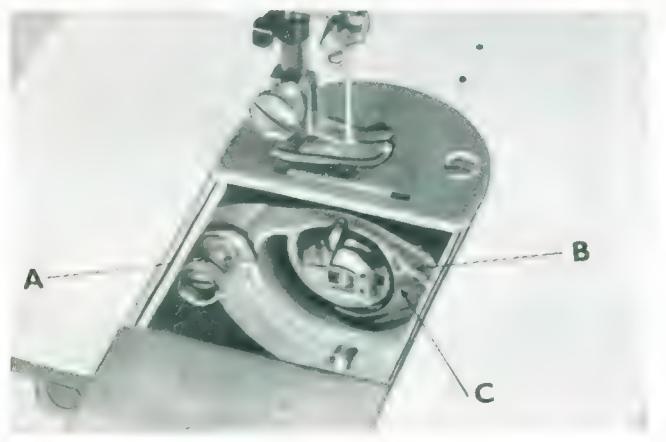
To increase the pressure on the presser foot for feeding heavy materials, turn the adjusting screw 'A' down in a clockwise direction until the pressure is enough for the machine to feed the material. For light, thin materials, release the pressure by turning the screw in the opposite direction.

Always return the adjusting screw to its original position after use in either extreme direction.

## 16. TO REGULATE THE LENGTH OF STITCH

- (a) Loosen the thumb screw (A) and move down to the bottom of the slot.
- (b) Move lever (B) down until it is level with the figure indicating the number of stitches required.
- (c) Move the thumb screw upwards until it comes against the stop, and then tighten. The machine will now sew forwards making the number of stitches indicated.
- (d) If it is desired to reverse the stitching, raise the lever (B) upwards until it comes against the stop. The machine will now sew backwards making the same length of stitch.

**NEVER TRY TO SEW WITH THE LEVER IN THE NEUTRAL POSITION.**

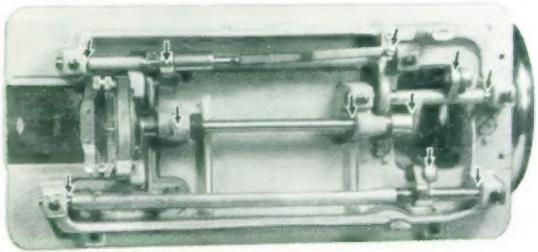
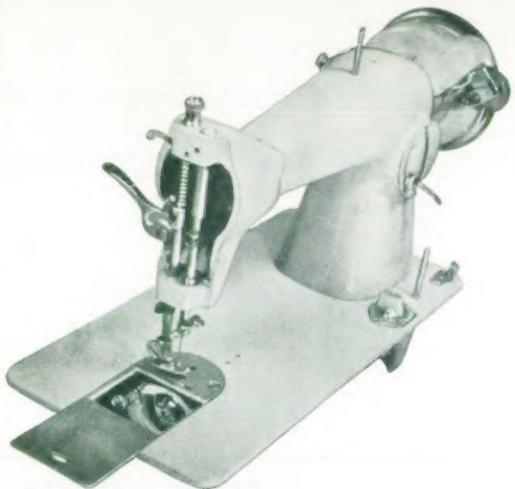


TO WORK THE DROP-FEED, simply turn the dropfeed knob to "EMBR". The feed dog is then out of the way. For regular sewing turn the drop-feed to its normal position.

#### 17. TO CLEAN THE SHUTTLE MECHANISM

When the machine is continually in use, it is necessary to clean the race at least once a month.

- (a) Take out the bobbin case, and release the clip (A) on both sides of the shuttle race by rotating the notch point outward.
- (b) Remove the race ring (B) and take out the shuttle hook (C).
- (c) Remove accumulated thread, etc., from retaining ring, hook and race body.
- (d) Oil again, wipe off surplus oil and replace.



## 18. OILING THE MACHINE

- (1) Use only a good grade oil. Inferior oils may cause the machine to become sluggish.
- (2) Use only oil specified "For Sewing Machines."
- (3) If you use the machine frequently, it should be oiled every day, preferably when putting the machine away. When not in constant use, oil the machine just before using.
- (4) Use ONE drop of oil on bearings, and wherever one part rubs against another, or turns within another part.
- (5) Some such parts are visible to the eye, others are hidden inside the casting, so look for all oil holes in the casting as indicated by arrows in the picture. Insert the oil can nozzle well into the oil hole.
- (6) Before oiling the oil hole to the RIGHT of the spool pin on top of the machine, turn the balance wheel until the needle is DOWN to its lowest point, and look well into the oil hole to see that the oil receptacle on the shaft is in position.
- (7) Also remove the face plate by loosening the screw near the top and lifting the face plate up and off. Turn the balance wheel slowly by hand and watch the mechanism under the face plate to see which parts move and require oil.
- (8) Put three drops of oil in the bobbin raceway, after the race has been removed.

The machine is also to be oiled from the back.

- (i) Loosen the screw holding the metal plate, move the plate out of the way and tighten the screw to hold it there.

- (ii) Turn the balance wheel slowly in order to see which parts move and require oil.
- (iii) Now tilt the machine back and again turn the balance wheel slowly to locate the bearings and other moving parts. Here, too, you will find some oil holes in the castings.
- (iv) Wipe away all excess oil from all parts of the machine, and run the machine rapidly for a minute to allow the oil to penetrate into the bearings.
- (v) Finally, sew some scrap material to be sure that no oil will drip from the needle bar on to your material.

## 19. HINTS ON SEWING

- (a) Upper thread breaking :—If the needle thread breaks, this is probably due to one of the following reasons ;—
  1. Machine improperly threaded.
  2. Tension regulator too tight.
  3. Thread unsuitable for the needle.
  4. Needle improperly set.
  5. Bent or blunt needle.
  6. Balance wheel reversed.
- (b) Lower thread breaking :—
  1. Thread wound unevenly or excessively on bobbin.
  2. Bobbin case spring worn.
  3. Bobbin case improperly threaded.
- (c) Needle breaking :—
  1. Needle bent.
  2. Material too thick for needle.
  3. Material pulling when stitching.
  4. Presser foot loose.

- (d) Irregular stitches :—
  1. Wrong type of needle thread.
  2. Wrong type of bobbin thread.
  3. Insufficient pressure on presser foot.
  4. Wrong setting of needle.
  5. Thread unevenly wound on bobbin.
  6. Position of feed dog too low.
  7. Bent needle.
- (e) Material wrinkling :—
  1. Tension of both threads too tight.
  2. Presser foot improperly set.
  3. Stitch too long for type of material.
  4. Thread too heavy for type of material.
- (f) Stitches looping :—
  1. Wrong tension on upper or lower threads.
  2. Threads unsuitable for type of needle.
- (g) Machine working sluggishly :—
  1. Requires oiling
  2. Belt too tight.
  3. Shuttle race dirty.

**CORRECT SIZES OF NEEDLES AND THREADS**  
**Always use JONES C. B. or SYSTEM 705 Needles**

GRADE	NEEDLE SIZE			TYPE OF FABRIC TO BE SEWN	SIZES OF THREAD		
	JONES C.B.	SYSTEM 705	15 X 1		COTTON	LINEN	SILK
Fine	0	65	9	Very thin muslin, cambrics, linen.	100/150		
Medium Fine	B	70	11	Very fine calicos linen, shirtings, silk dresses and summer fabrics.	80/100		24/30
Medium	1/2	80	14	General household sewing, shirtings, calicos, curtains.	60/80		24/30
Light Heavy	1	90	16	Heavy calicos, light woolen goods, heavy silk.	40/60	80/100	24/30
Medium Heavy	2	100	18	Tickings', woolens trousers, boys clothes.	30/40	70/80	16/24
Heavy	3	110	20	Heavy woolens, bags, heavy coatings, trousers.	24/30	60/80	

